



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

SWA10A-300
Job Sheet 169726



Part No: SWA10A-300

Job Qty: 2 ea

Part Name: Bearing Housing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/20/17

Job Tracking No:

Due Date: 12/29/17

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG SWA10A-300 Rev 5

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea		12/28/17	0.00	0.00	Start Up Machining-3		
100	Bandsaw	2 pcs		12/28/17	0.00	0.20	Bandsaw1		
110	Mori Seiki	2 pcs		12/29/17	0.00	2.00	MORI NLX		
120	QC	2 pcs		12/29/17	0.00	0.00	QC2		
130	QC	2 pcs		12/29/17	0.00	0.00	QC8		
140	Packaging	2 pcs		12/29/17	0.00	0.00	Packaging3 GA		
150	QC21-SA	2 Ea		12/29/17	0.00	0.00	QC21		

Part Op 100 - Cut Blanks to 3.315" 560"

Descriptions: 110 - 1-Machine as per DWG. FB 711 FOLIO REV: _____ DWG REV: _____ 2-Deburr

JAN 26 2016

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M17-4-H1150-R4.000	1	0	0	0

Part Specifications

Specifications could not be found.

Plex 12/20/17 11:25 AM Dart.lajeunesse.marie

3.14 mm

2.47 pcs

.604' SD 30422

DART
AEROSPACE
S034286



Bearing Housing

PART NO: SWA10A - 300
Original Serial #: S034286
Revision:
Operation:
Change No:

Start up Operation 01/22/18

Job No: 169726

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

169 726

DART AEROSPACE LTD		Work Order: 170121
Description: <u>Bearing housing</u>		Part Number: 170121
Inspection Dwg: <u>SWA10A-360</u> Rev: 5		Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.235	+0.003/-0.000	1.237	✓		Jern LPO8	
.125	+/- .005	.125				
1.020	+/- .005	1.017				
.245	+/- .005	.247				
1.017	+/- .005	1.018				
.095	+/- .005	.095				
.03x45°	+/- .01 x .5°	.03x45°				
.02x45°	+/- .01 x .5°	.02x45°				
Ø 2.165	+/- .001	2.164			Mic LPO8	
Ø 2.3521/2.3520		2.3524			NLX 2500	
R.015	+/- .005	.015			Red gage	
Ø 3.071	+0.003/-0.000	3.073			MK 104-137	
Ø 3.120	+/- .005	3.119				
Ø 3.500	+/- .010	3.517			Mic 112-177	
.120	+0.005/-0.000	.122			Mic 005	
3/2 1608-113	G-D - NO G-D	G-D			Vern LPO8	
Ø 3.505	+0.000/-0.002	3.504			G-D gage	
Ø 3.710	+/- .006	3.7075			Mic 112-177	
Ø 3.950	+/- .005	3.951			MK 104-137	
3.430	+/- .005	3.430			Height gage	Height gage
.680	+/- .005	.679				
Ø 2.70	+/- .01	2.702			Vern LPO8	
R.25	+/- .01	.25			Rad gage	
.07x45°	+/- .01 x .5°	.075x45°			Jern LPO8	
.04x45°	+/- .01 x .5°	.04x45°				

Measured by: <u>JP</u>	Checked by: <u>gmk</u>	QC Inspector:
Date: <u>18-01-21</u>	Date: <u>18/01/23</u>	Date:

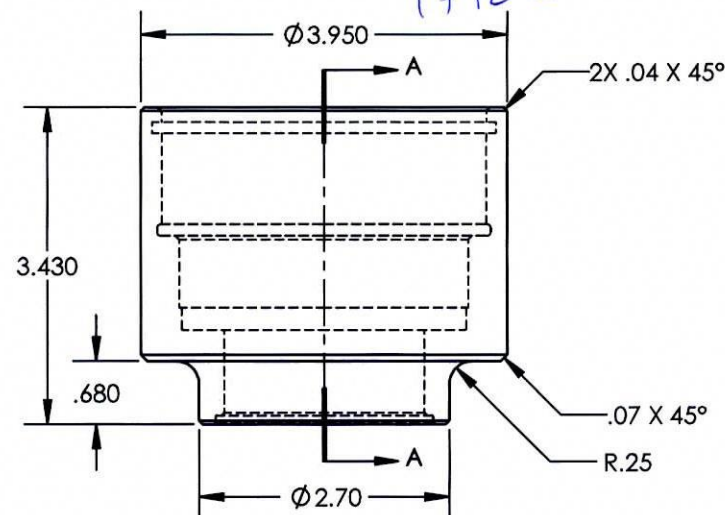
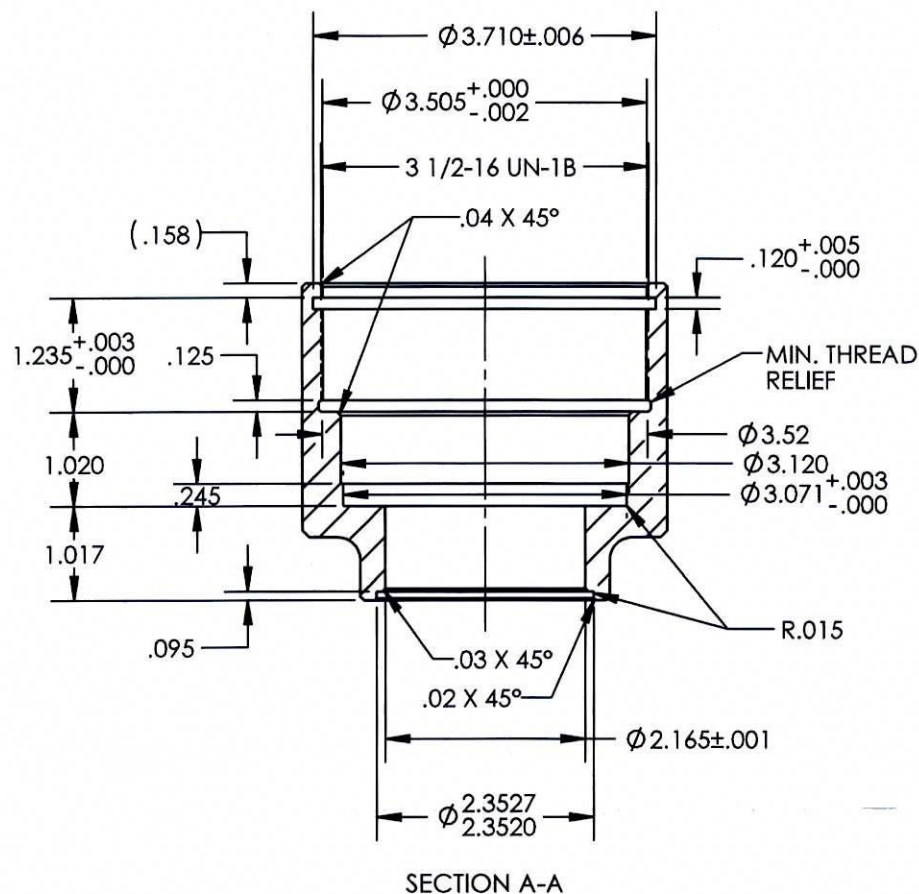
Engineering Approval: (if necessary)	Date:
---	-------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

This drawing, specifications, and concepts contained here in are the sole property of Dart Aerospace, and may not be reproduced or used in any fashion without the prior written permission of Dart Aerospace Eugene, OR.

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2		AS DRAWN BY CANAM	11/12/2012	JAG	
3		CH'D TOLERANCE OF Ø2.352+-.003/-0.000 TO A LIMIT DIM.	11/16/2012	JAG	
4	15-0304	UPDATED TO NEW DRAFTING STANDARDS. ADDED MAT'L OPTION H1075.	10/16/2015	DPD	JAG
5	16-0252	CH'D THREAD DIM WAS 3-1/2 -16 UN -2B IS 3-1/2 -16 UN -1B, ADDED MIN. THREAD RELIEF NOTE.	12/5/2016	RJC	JAG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 169726 M-1



			
TITLE			
BEARING HOUSING			
DWG NO.			REV
SWA10A-300			5
MATERIAL SS 17-4 H1150/H1075		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX ± .006 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 8° .X ± .1 SURFACES = 125/√	
FINISH			
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .01R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY:	CANAM	USED ON MODEL	
CHECKED:	MACKOVJAK		
OPPS APPR:	ANDERSON		
QA APPR:	LINDSAY		
APPROVED:	GILBERT		
SCALE	1:2	DATE	2/21/2002
		SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			SWA10A-300	1	BEARING HOUSING	SS 17-4 H1150/H1075	